

Work Order ID 59939

Thursday, June 17, 2010 12:57:54 PM



Page 1

Item ID: D2671

Revision ID:

Item Name: Bearpaw, 206 Narrow

Start Date: 6/17/2010 Start Qty: 8.00

Required Date: 6/24/2010 Req'd Qty: 8.00

Reference:

Approvals: Process Plan: PH Date: 10-6-19 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2671	Rev B1								

120



Waterjet
FLOW CNC Waterjet

FLOW WATER JET

Memo

Cut Blank as per File D2671_BLANK

0.00

0.00

B 10-6-24

(8)

130



HAAS 1
HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio FA790 and Dwg D2671 Identify as D2671
3-Debur

0.00

0.00

B 10/06/28

8 8

140



QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

B 10/06/28

8 8

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2671

Revision ID:

Item Name: Bearpaw, 206 Narrow

Start Date: 6/17/2010 Start Qty: 8.00

Required Date: 6/24/2010 Req'd Qty: 8.00

Reference:

Accept



Setup

Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

JP 10/06/28

8

8

180



Packaging

Packaging

Identify as per dwg & Stock Location:
Packaging

Memo

0.00

0.00

JP 59939

10-6-29

40

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

10/06/29

U 10/06/29

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 59939

Parent Item: D2671

Parent Item Name: Bearpaw, 206 Narrow



Start Date: 6/17/2010

Required Date: 6/24/2010

Start Qty: 8.00

Required Qty: 8.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10 		Purchased	No			120	sf	279.1000	2.7	21.6			
UHMW 1" Black												AB 10-6-24	

Location

Loc Qty

Loc Code

MAT

279.1

112186

20.7

113903

88

114624

170.4

112186

8

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	59939
Description: Bearpaw		Part Number:	D2671
Inspection Dwg: D2671	Rev: B1	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.063	✓			
B	5.500	+/-0.030	5.508	✓			
C	0.200	+/-0.030	.200	✓			
D	R0.250	+/-0.030	.250	✓			
E	0.625	+/-0.030	.617	✓			
F	0.250	+/-0.010	.245	✓			
G	0.950	+0.030/-0.010	.950	✓			
H	0.25 x 45°	+/-0.030	.250	✓			
I	0.375	+/-0.010	.384	✓			
J	12.750	+/-0.030	12.750	✓			
K	Ø0.260	+0.005/-0.000	.260	✓			
L	Ø0.93	+/-0.030	.925	✓			
M	0.30	+0.030/-0.000	.310	✓			
N	4.250	+/-0.030	4.250	✓			
O	0.375	+/-0.030	.382	✓			
P	2.000	+/-0.030	2.000	✓			
Q	4.250	+/-0.010	4.25	✓			
R	9.000	+/-0.010	9.000	✓			
S	15.750	+/-0.030	15.750	✓			

Measured by:	AT
Date:	10/04/24

Audited by:	DJP
Date:	10/04/28

Prototype Approval:	N/A
Date:	

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF	+

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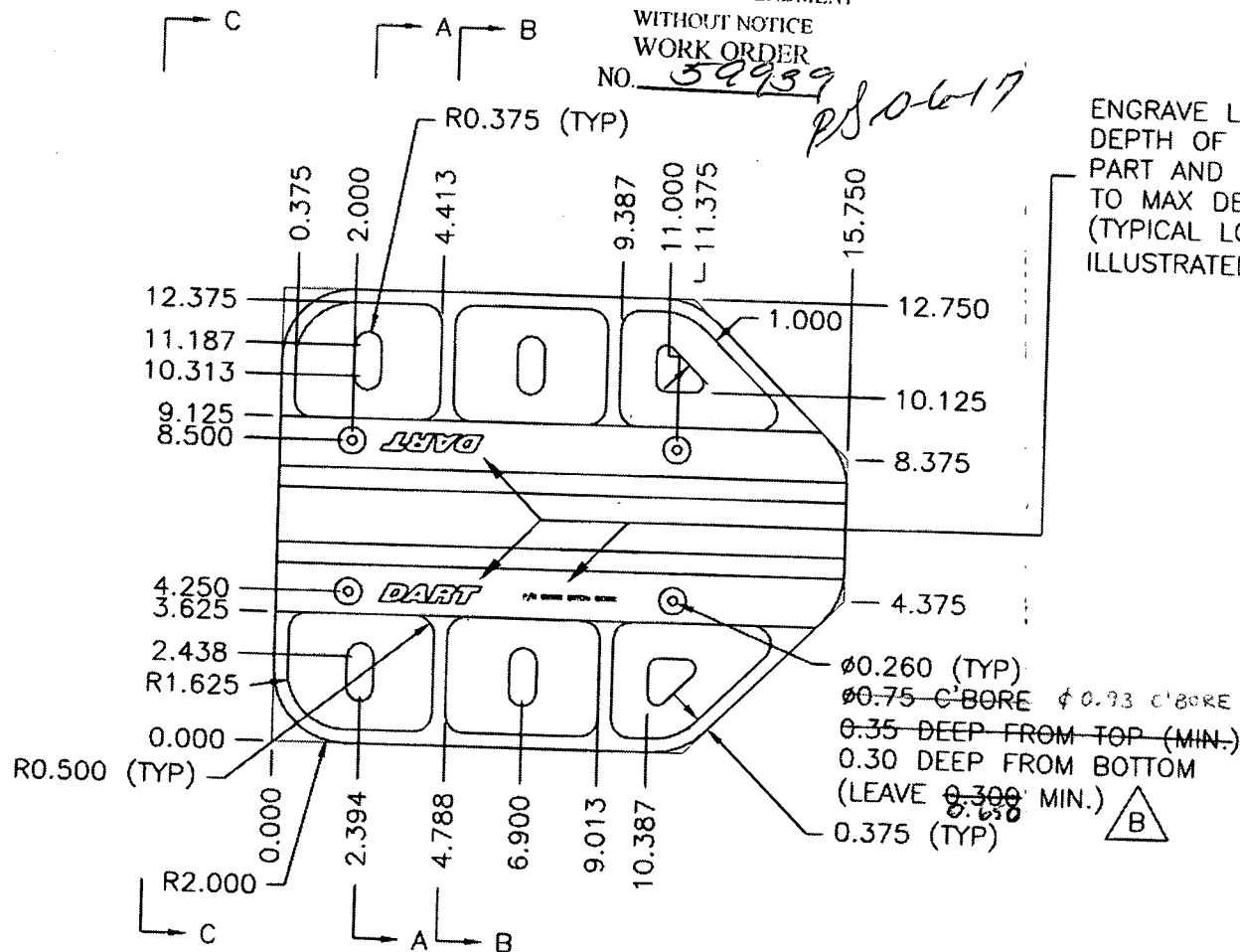
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39939 *ps 0617*

B1 02.12.17 $\phi 0.93$ WAS $\phi 0.75$ ~~17~~



ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

RELEASED
99.06.17 KE



EFFECTIVE DEOS
9143



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>KE</i>	APPROVED <i>KE</i>	HAWKESBURY, ONTARIO, CANADA
DATE 98.05.19	DRAWING NO. D2671	REV. B
	TITLE BEARPAW	SHEET 1 OF 2
	NEW ISSUE	SCALE 1:5
	CHANGE C'BORE, R1.58 WAS R1.50	

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

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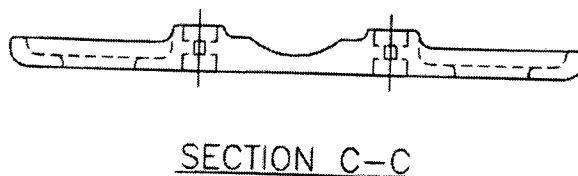
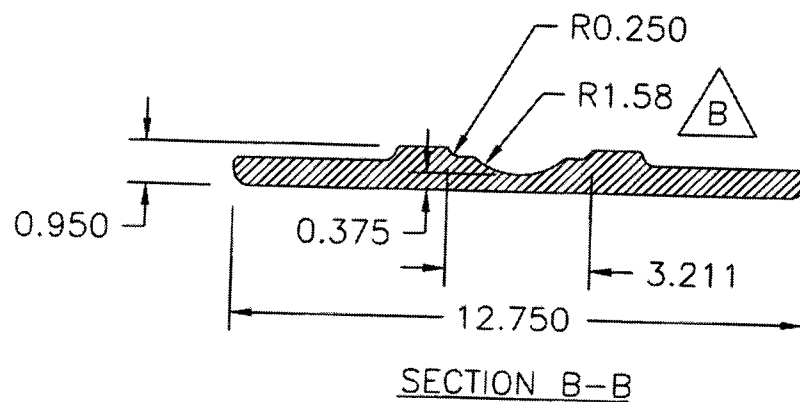
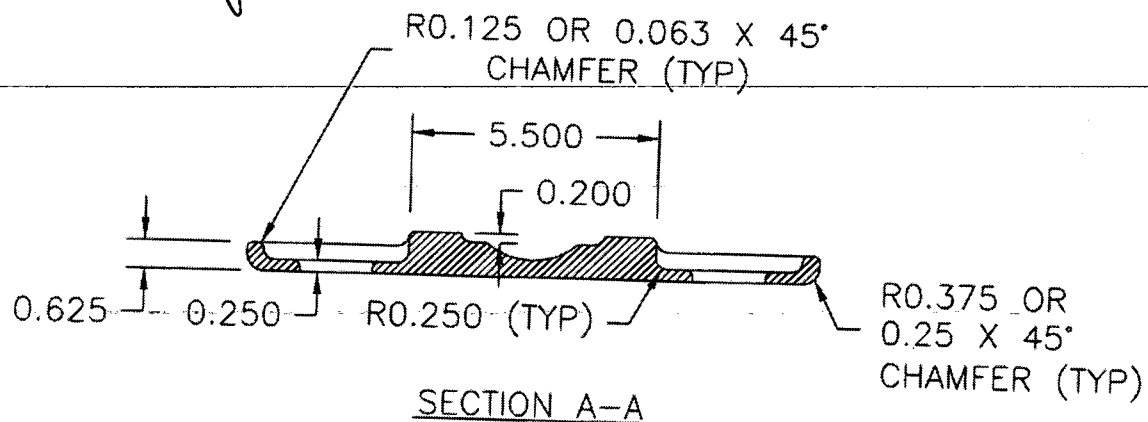
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>DIB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2671	REV. B
DATE 98.05.19		TITLE BEARPAW	SHEET 2 OF 2
			SCALE 1:4

RELEASED
98.06.17 KE

w/o 30939



W/O:		WORK ORDER CHANGES					
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